

Date: Thursday, 3/23/2006 3:52:16 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE		
Job Number	: 26368		Part Number	: D29322		
Estimate Number	: 10832		Drawing Number	: D2932 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/23/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev:	: NC		Material	: N/A		
First Issue	: 3/23/2006 Type : MACHINED PARTS		Due Date	: 4/10/2006 Qty: 4 Um: Each		
Previous Run	: 25871					
Written By	<u>See JF Comment Below</u>					
Checked & Approved By	<u>JF 06.03.24</u>					
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: <u>25341</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number / <u>JF</u> 1-Inspect part number and batch number are programmed correctly. <u>JF</u> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet <u>/</u> 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet <u>/</u> 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet <u>/</u> 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:52:17 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 26368

Part Number: D29322

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

9nL06/04/25 4

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Mel.F. 06-04-27 4

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC oct/05/01 (4)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Identify and Stock

Location: ST476

11/09/02 (4)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST476

11/09/02 (4)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

11/09/02 (4)

Job Completion



11/09/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

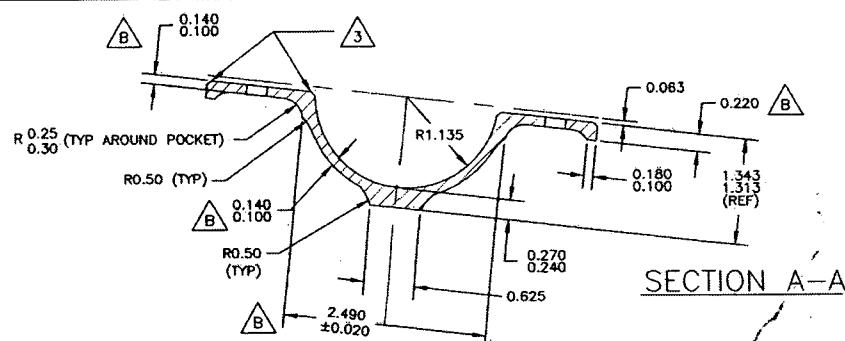
DART AEROSPACE LTD				Work Order:	26368
Description: 206 Saddle, Outboard, Right side				Part Number:	D2932-2
Inspection Dwg: D2932 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

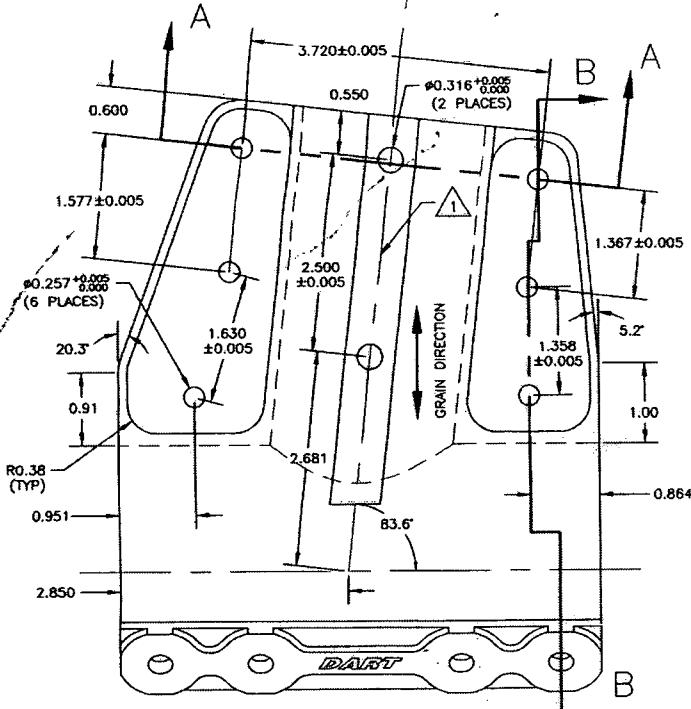
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.124	.125	.126		
B	0.100	0.140		.126	.122	.124	.124		
C	0.100	0.140		.130	.127	.130	.128		
D	0.210	0.230		.225	.226	.227	.226		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.237	.237	.2375	.239		
N	0.100	0.140		.122	.120	.121	.121		
O	0.540	0.560		.549	.549	.548	.549		
P	0.490	0.510		.500	.498	.499	.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.498	2.498	2.497	2.498		
S	0.240	0.270		.254	.255	.254	.255		
T	0.100	0.180		.142	.142	.142	.142		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.141	1.141	1.133	1.138		
Y	1.565	1.585		1.574	1.574	1.575	1.576		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD	Audited by:	SNL
Date:	06.04.18	Date:	06/04/25

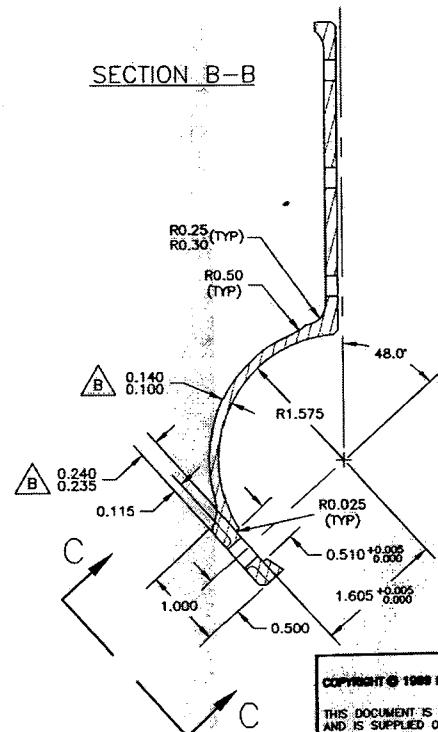
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#



SECTION A-A



**SECTION B-B**



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1** ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2** ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3** CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4** CHAMFER 0.050" x 45°

RELEASED  
00-05-31 87

1.605 <sup>+0.005</sup> 0.000		00.05.29 CHANGED GEOMETRY AND MATERIAL		
A 99.10.29		NEW ISSUE		
DESIGN <i>[Signature]</i>		DRAWN BY <i>RF</i>	DART DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>	DRAWING NO. D2932	REV. B SHEET 1 OF 1
DATE 00.05.29		TITLE SADDLE, OUTSIDE		

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